

Work Order ID 70615

Monday, June 13, 2011 12:34:14 PM



Page 1

Item ID: D3302-1

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 6/10/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 6/10/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3302	Rev B2

100



FLOW WATER JET

Waterjet

Memo

0.00

TB11-6-23

FLOW CNC Waterjet

6061-063

1-Cut as per Dwg D3302 Dwg Rev: B2 Prog Rev: B2 2-
Deburr if necessary

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

0.00

TB11-6-23

120



QC8- Inspect parts - second check

QC

Quality Control

0.00

TB11-6-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
**Set Up/
Run Hours**
Tool ID
Tool #
**Plan
Code**
**Accept
Qty**
**Reject
Qty**
**Reject
Number**
**Insp.
Stamp**

160



Chemical Conversion Coat per QSI005 4.1

0.00

80 BK 11-7-4.

HandFinish

Memo

0.00

Hand Finishing

170



QC3- Inspect Part Finish

0.00

80 M-f 11/07/04

QC

Memo

0.00

Quality Control

180



Identify as per dwg & Stock Location: 143

0.00

11/7/04 SHeo

Packaging

Memo

0.00

Packaging

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Required Date: 6/22/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

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Picklist Print

Monday, June 13, 2011 12:34:19 PM

Page 1

Work Order ID: 70615



Parent Item: D3302-1



Parent Item Name: Doubler

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev: A 04.09.02 New issue KJ/JLM
IPP Rev:B Now on Waterjet 07-06-25 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased		No		100	sf	285.0000	0.7708	4.868211	6.		

6061-T6 .063 Sheet



Location	Loc Qty	Loc Code
MAT021	285	
116308	29	
117285	256	117285

(8)

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DART AEROSPACE LTD	Work Order:	
Description: Doubler	Part Number:	D3302-1
Inspection Dwg: D3302 Rev: B2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: B	Audited by: D	Prototype Approval: N/A
Date: 11-6-73	Date: 14/04/73	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.03.04	Revised dimensions per Dwg revision	KJ/JLM	
C	06.03.09	Dwg Rev update	KJ/JLM	✓

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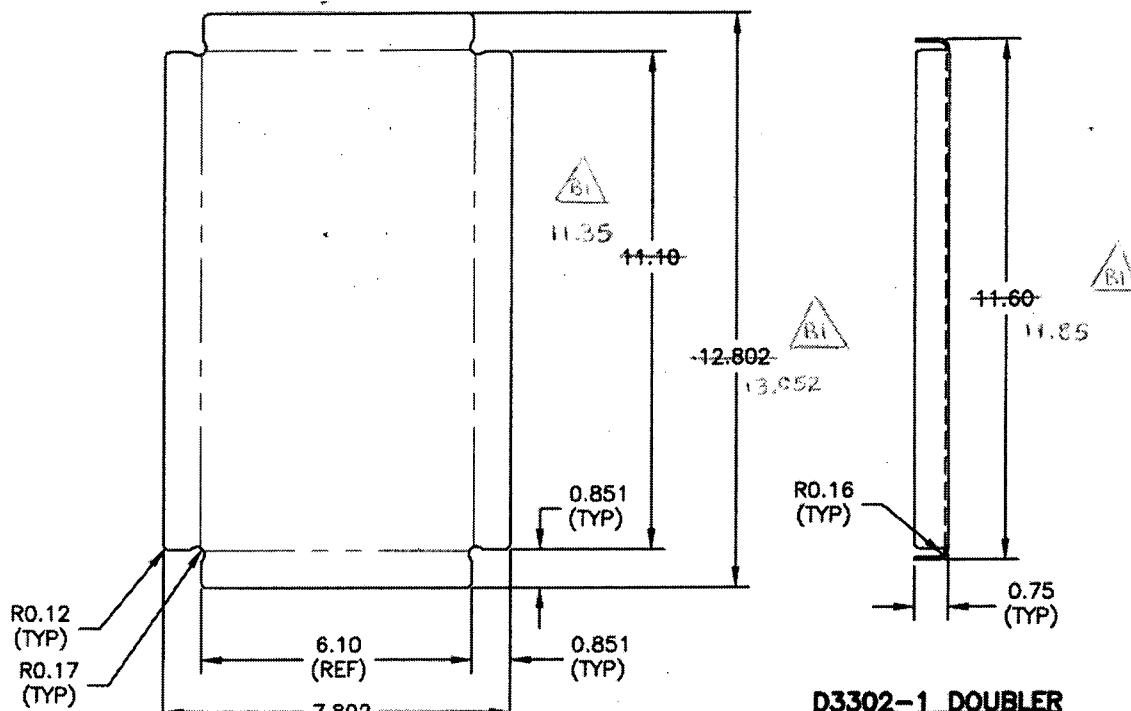
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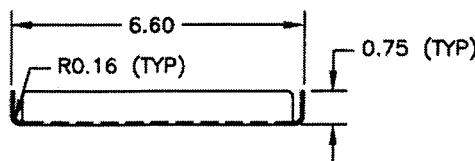
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. REV. B D3302
DATE		SHEET 1 OF 4
04.11.18		TITLE SCALe DOUBLER 1:4
A	04.07.06	NEW ISSUE
B	04.11.18	REMOVE HOLES
B1	04.12.15	ADDED 0.25" TO THE LENGTH FOR -1/3
B2	03.03.21	7.25 WAS 7.34; 8.952 WAS 9.042; 7.75 WAS 7.84 FOR D3302-3

RELEASED
04.11.23



**D3302-1 DOUBLER
BEND DETAIL**

D3302-1 FLAT PATTERN



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70615

70615

D3302-1 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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